

1 ABSTRACT OF THE DISCLOSURE

2 This invention relates to polyisocyanate compositions comprising (a)
3 polyisocyanate, and (b) a monomeric carbodiimide. The polyisocyanate compositions
4 are particularly useful in phenolic urethane foundry binder systems. The invention also
5 relates to foundry mixes prepared with (a) a phenolic urethane binder containing the
6 polyisocyanate composition, and (b) a foundry aggregate, as well as foundry shapes
7 prepared by the no-bake and cold-box processes, which are used to make metal castings.